

Work Order ID 69186

Wednesday, May 04, 2011 11:40:21 AM



Page 1

Item ID: D3281-1L08

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, Fwd LH

Stop



Start Date: 5/4/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CJDate: 11/05/04 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3281	Rev F								
100		0.00				x4			<u>JL</u>
	HAND FINISHING THERMOFORMING								<u>11/05/05</u>
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks								

105



Dry Material

0.00

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°FTime IN: 2:00 amTime OUT: 7:00 am11/05/05JL
11/05/05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 5/13/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

110

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Thermoform

THERMOFORMING MACHINE

0.00

x4

Sh

Thermoforming Machine

Memo

0.00

Thermoform as per Dwg. D3281 and Folio FTA 011
Dwg. Rev. F
Folio Rev. D

11/05/05

120



QC2- Inspect parts off machine FAI/FAIB

0.00

x4

Sh

QC

Quality Control

Memo

0.00

11/05/05

130



HAND FINISHING THERMOFORMING

0.00

x4

Sh

Thermoform

Thermoforming Machine

Memo

0.00

Trim to Finished Dimensions

11/05/05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69186

Page 3

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Item ID:	D3281-1L08	Accept		Setup	Start	
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Revision ID:**Item Name:** Floor Protector, Fwd LH**Start Date:** 5/4/2011 **Start Qty:** 4.00**Cust Item ID:****Required Date:** 5/13/2011 **Req'd Qty:** 4.00**Customer:****Reference:**

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00							<i>He</i> 16/05/09
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150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00	0.00	<i>Fulstop</i>	<i>(dq)</i>				
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160 Packaging Packaging	Packaging Memo	0.00	0.00			<i>nk/sk4</i>			
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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action			Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date					

NOTE: Date & initial all entries

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Page 4

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Item Name: Floor Protector, Fwd LH

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Start Date: 5/4/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

QC21 - Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

11/15/11 HJ

MC
11-05-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, May 04, 2011 11:40:17 AM

Work Order ID: 69186



Parent Item: D3281-1L08



Parent Item Name: Floor Protector, Fwd LH

Start Date: 5/4/2011

Required Date: 5/13/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev. A 10.02.24 New Issue LL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	2,220.704	5	21.05263			

Lexan Sheet



Location	Loc Qty	Loc Code
therm	2220.70472	
113127	2220.70472	21.05263

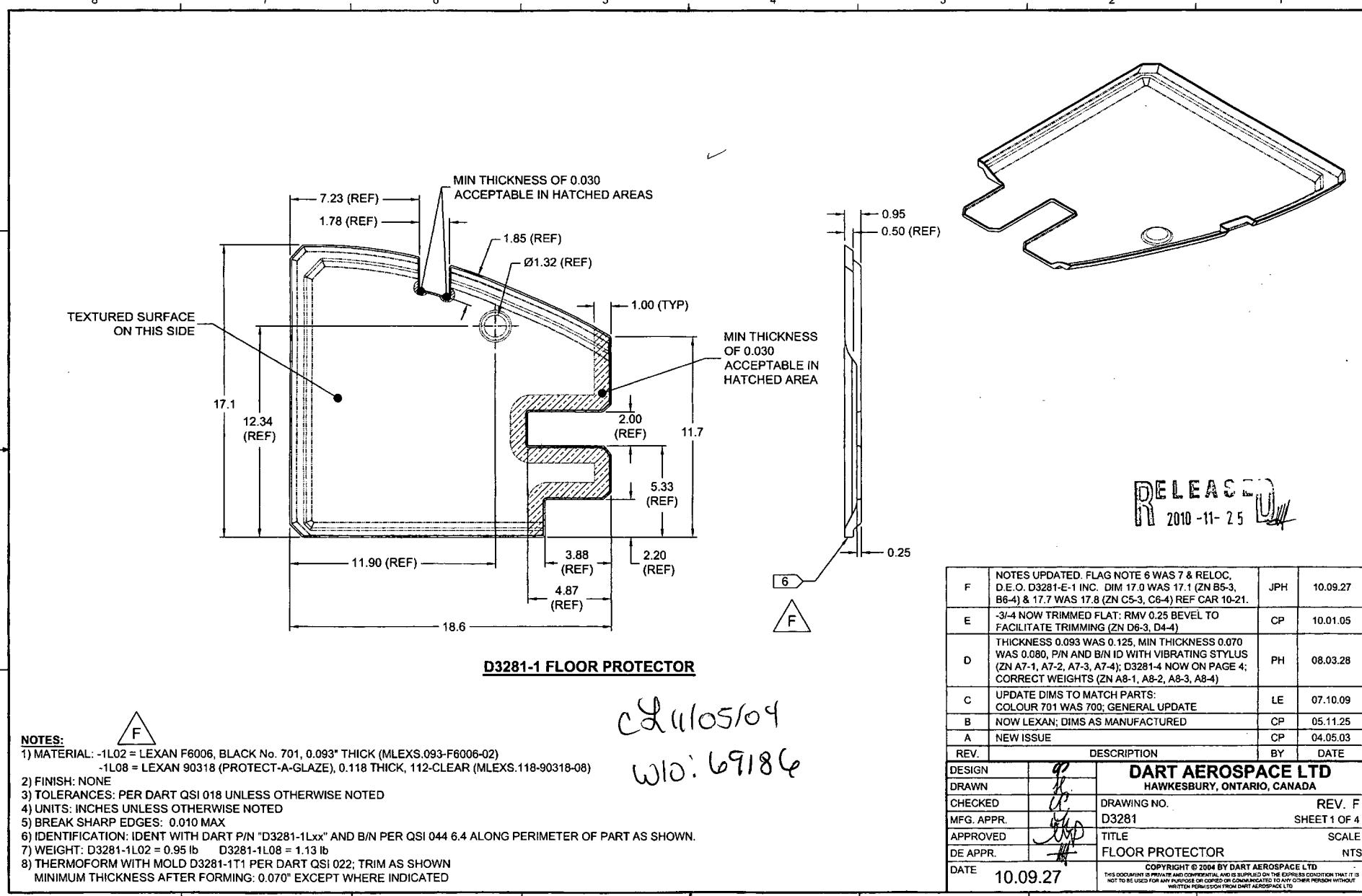
SL
11/05/08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action			Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date					

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69186
Description: Floor Protector, Fwd LH		Part Number:	D3281-1
Inspection Dwg: D3281	Rev: E/F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *Dh.*

Date: 11/05/05

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.6	+/-0.100	18.55"	✓		TAPE DL-01	
17.1	+/-0.100	17.0"	✓		TAPE DL-01	
11.7	+/-0.100	11.6"	✓		TAPE DL-01	
0.95	+/-0.030	0.975"	✓		vern DL-01	
0.25	+/-0.030	0.265"	✓		vern DL-02	
0.030	Min	0.060"	✓		CAL TH-DT	
0.070	Min	0.102"	✓		CAL TH-DT	

Measured by: *Dh.*

Date: 11/05/05

Audited by: *S*

Date: 11/05/05

Preliminary Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	
D	10.09.01	Dwg Rev updated	KJ <i>jj</i>	<i>dt.</i>